

5/43

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	24635
<b>Description:</b> Wearplate	<b>Part Number:</b>	D3321-3
<b>Dwg:</b> D3321 Rev. A page 2 of 2 B 05.10.21 JAH	<b>Qty:</b>	10
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JAH	05.10.21	10
2	PG	Issue P/O: 200823 Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3321 Possible Supplier: Industrial Laser Material release note is required	L	05.10.21	10
3	RG	Receive and inspect for transit damage Ensure material release note is attached	CL	05.10.21	10
4	QC6	Inspect dimensions as per inspection template D3321-3T1	JB	05.11.17	10
5	GA	Deburr if necessary		N/A	
6	GB	Form using DT8179 Die & DT8774 as per Dwg D3321 Dwg Rev: B	JB	05.11.23	9
7	QC6	Inspect dimensions as per Dwg D3321		05.12.01	9
8	WS	Weld hard surface using D3321-3T3 as per QSI 004 and Dwg D3321 DT8824 Qty Part Number Description Batch A/R N/A 7560 Hardcoat Rod M19874		05.12.19	9
9	QC9	Inspect weld		05.12.19	9
10	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	FC	05.12.20	9
11	QC3	Inspect Powder Coat	M	05.12.21	9
12	ST	Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3321-3, B/N: BXXXXX For Product Eligibility see PDA04-17 and Stock Loc 414		06.01.03	9
13	AC	Cost / part:	SCC	06.01.04	9
14	DC	Close W/O Inspect Level 21		06.01.04	9

Rev	Date	Change	Revised By	Approved
A	05.05.12	New issue	KJ/JLM	

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

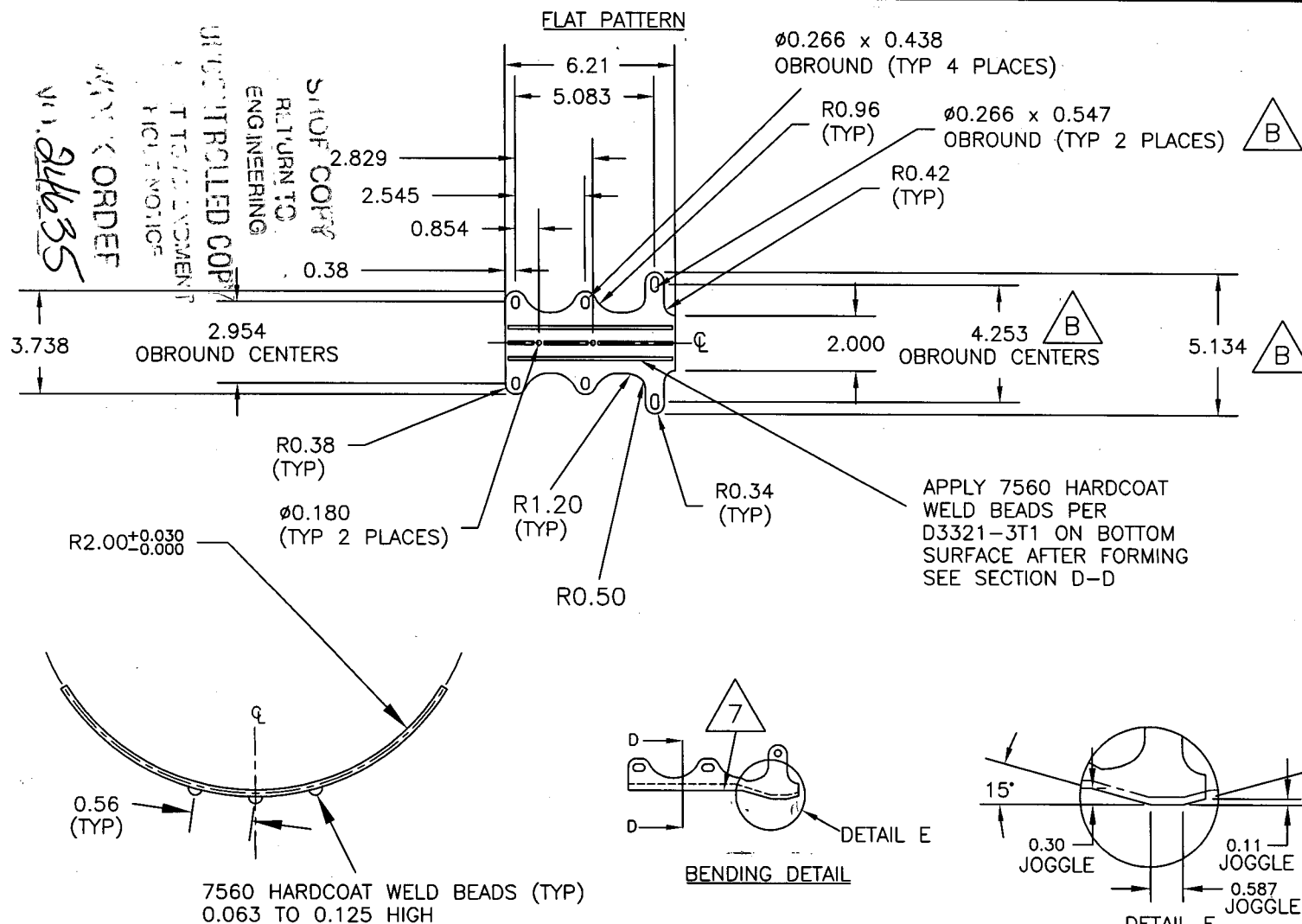
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 06/01/04

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

PRELIMINARY ISSUE



SECTION D-D  
(SCALE 1:1.5)

# D3321-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE
- 6) ALL DIMENSION ARE IN INCHES
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3321-3 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN	BY	DRAWN BY	DART AEROSPACE LTD
CHECKED	BY	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	05.04.29	DRAWING NO.	D3321
TITLE	WEARPLATE	SHEET	2 OF 2
SCALE	1:6	REV.	B

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Oct 20, 2005  
04:09 pm

Work Order No : 0024635  
Project Name : D3321-3  
Project For : WK543  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3321-3  
Description : Wearplate, Aft End  
Manufactured : Yes  
Amount Req'd : 10  
Amount Done : 0  
Start Date : 10-20-05  
Est Finish Date : 10-31-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

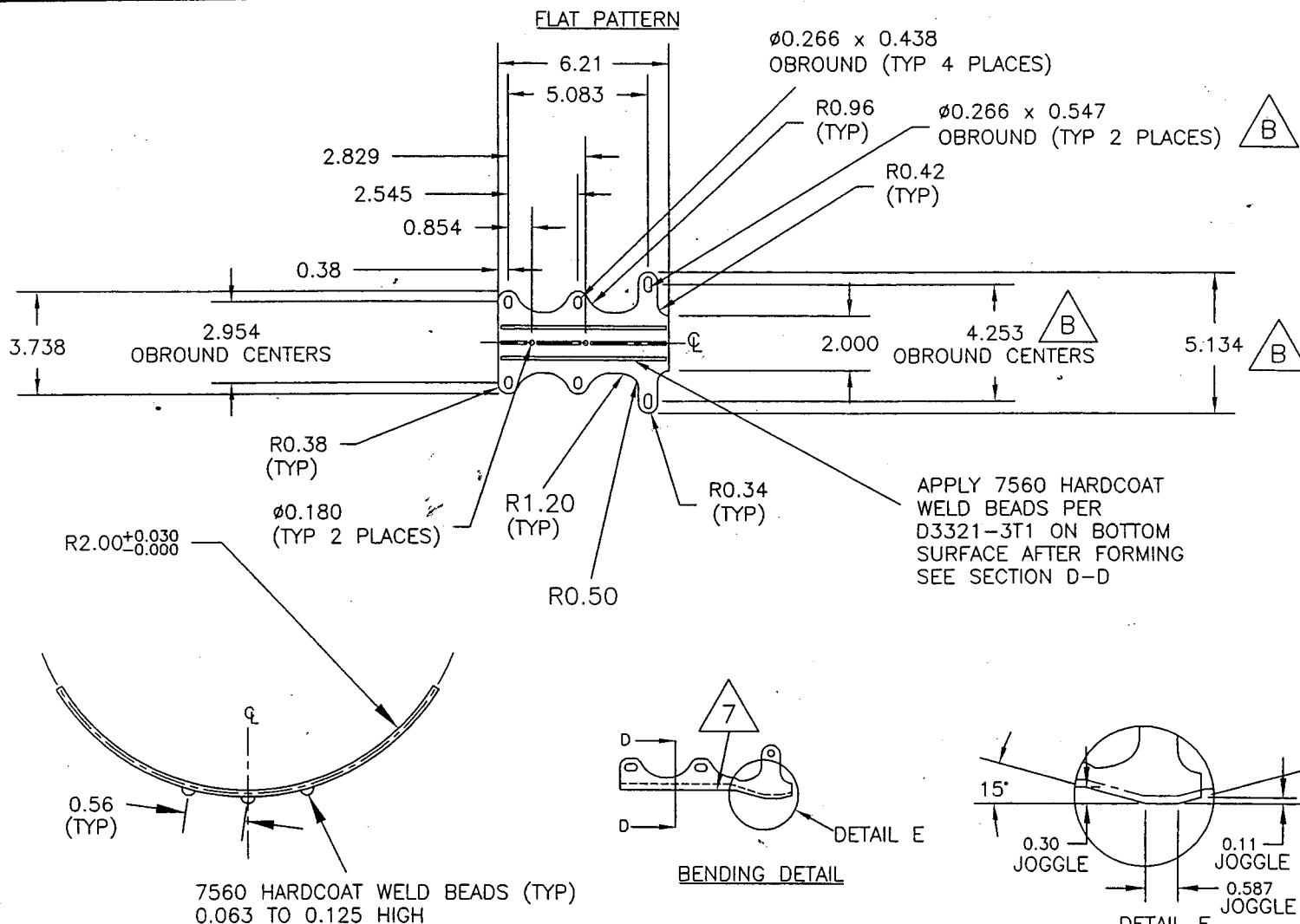
	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

# PRELIMINARY ISSUE



DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED		APPROVED		HAMKESBURY, ONTARIO, CANADA
DATE	05.04.29	TITLE	D3321	REV. B
				SHEET 2 OF 2
				SCALE 1:6



SECTION D-D  
(SCALE 1:1.5)

## D3321-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE
- 6) ALL DIMENSION ARE IN INCHES
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3321-3 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-17"

NO. \_\_\_\_\_

WORK ORDER

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

SHOP COPY  
RETURN TO  
ENGINEERING

Date: Saturday, 11/19/2005 10:13:09 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : WEARPLATE
<b>Job Number</b> : 24635	
<b>Estimate Number</b> : 10763	
<b>P.O. Number</b> :	<b>Part Number</b> : D33213
<b>This Issue</b> : 11/19/2005 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3321 REV. B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> :
<b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 24548	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 11/26/2005 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est: A 05.05.12 New issue KJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: \_\_\_\_\_  
 Email or Ship DXF file to vendor  
 Laser Cut flat pattern per Dwg D3321  
 Possible Supplier: Industrial Laser  
 Material release note is required

2.0	D33213F	Wearplate, Aft End
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3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage  
 Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Inspect dimensions as per inspection template D3321-3T1

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

6.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

1- Form using DT8179 Die & DT8774 as per Dwg D3321 Rev: \_\_\_\_\_

Date: Saturday, 11/19/2005 10:13:09 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 24635

Part Number: D33213

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3321-3T3 as per QSI 004 and Dwg D3321 Rev: \_\_\_\_

Qty Part Number Description Batch

A/R N/A 7560 Hardcoat Rod \_\_\_\_\_

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3321-3, B/N: BXXXXX

For Product Eligibility see PDA04-17

and Stock

Location: \_\_\_\_\_

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 08, 2005  
12:41 pm

Work Order No : 0024635  
Project Name : D3321-3  
Project For : WK543  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3321-3  
Description : Wearplate, Aft End  
Manufactured : Yes  
Amount Req'd : 10  
Amount Done : 0  
Start Date : 10-20-05  
Est Finish Date : 10-31-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00